



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3067-1

Job Sheet 178599



Part No: D3067-1

Job Qty: 120 ea

Part Name: End Plate



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/4/18

Job Tracking No:

Due Date: 6/4/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP: 03.01.21 Remove step 6 (Deburr) KJ IPP Rev:B Now on Water jet 06-06-16 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	120 Ea	6/4/18	6/4/18	0.00	0.00	Start Up Waterjet		da 18/06/03
100	Waterjet	120 pcs	6/4/18	6/4/18	0.00	1.59	Waterjet1		da 18/06/03
120	QC	120 pcs	6/4/18	6/4/18	0.00	0.00	QC8		38
130	Brake NC	120 pcs	6/4/18	6/4/18	0.00	0.95	Brake NC 1		85
140	QC	120 pcs	6/4/18	6/4/18	0.00	0.00	QC5		CPC
150	Packaging	120 pcs	6/4/18	6/4/18	0.00	0.00	Packaging3 Large Fab		CPC
160	QC21-SA	120 Ea	6/4/18	6/4/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut as per Dwg D3067

Descriptions: 130 - Bend as per Dwg D3067

150 - *** STOCK IN STEP CELL ***

DAG
21
9-00

JUN 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M5052H32S.063	5052-H32 .063 Sheet	7.5000 sf (.0625 ea)	90-Start up Operation	5004786

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M5052H32S.063	8	46	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	End Plate	2.900inches $\pm$ 0.010	2.910 2.890		
2	End Plate	2.749inches $\pm$ 0.010	2.759 2.739		

Plex 6/4/18 11:43 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																						
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																							
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																							
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																							
Large Fab ☐	Composite ☐	Supplier ☐																																																								
Date : _____	Sten #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																						
Description Work				Completed By																																																						
Dart Aerospace Ltd. 1270 Aberdeen Street Kitchener, ON N3A 1K7 CANADA TEL: 1 813 632-6200 Email: sales@dartaero.com www.dartaerospace.com Date: 06/04/18 Container No: S077589 Part: D3067 - 1 Job No: 178599 Serial No/Batch: S077589 Revision: Inspector: Exp Date: 06/04/2018 Instructions:				Lead hand / Supervisor Approval Verification																																																						
				QC / QA Coordinator Approval																																																						
Root Cause <table style="width:100%; border: none;"> <tr><td style="border: none;">Environment ☐</td><td style="border: none;">No Re-verification ☐</td></tr> <tr><td style="border: none;">Design ☐</td><td style="border: none;">Operator ☐</td></tr> <tr><td style="border: none;">Doc/Data ☐</td><td style="border: none;">Offset/Setup ☐</td></tr> <tr><td style="border: none;">Equip/Tooling ☐</td><td style="border: none;">Supplier ☐</td></tr> <tr><td style="border: none;">Handling/Pre ☐</td><td style="border: none;">Training ☐</td></tr> <tr><td style="border: none;">Material ☐</td><td style="border: none;">Use for Testing ☐</td></tr> <tr><td style="border: none;">Internal Transport ☐</td><td style="border: none;">Poor Information ☐</td></tr> <tr><td style="border: none;">Tribal Knowledge ☐</td><td style="border: none;">Rushing ☐</td></tr> <tr><td style="border: none;">LOA ☐</td><td style="border: none;">Product Improvement ☐</td></tr> <tr><td style="border: none;">Substation ☐</td><td style="border: none;">Process Improvement ☐</td></tr> <tr><td style="border: none;">Past Expiry Date ☐</td><td style="border: none;">Manufacturing Process ☐</td></tr> <tr><td style="border: none;">Misidentified ☐</td><td style="border: none;">Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☐	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	<table style="width:100%; border: none;"> <tr> <td style="border: none;">Crimp/Kink/kippie/wave ☐</td> <td style="border: none;">Inspection incomplete/Unqualified ☐</td> <td style="border: none;">Positioned Wrong ☐</td> </tr> <tr> <td style="border: none;">Cuffs ☐</td> <td style="border: none;">Contamination ☐</td> <td style="border: none;">Outside Dimensions ☐</td> </tr> <tr> <td style="border: none;">Crushing ☐</td> <td style="border: none;">Countersink ☐</td> <td style="border: none;">Over/Under tolerance ☐</td> </tr> <tr> <td style="border: none;">Heat Treat ☐</td> <td style="border: none;">Cut Too Short ☐</td> <td style="border: none;">Part Incorrect ☐</td> </tr> <tr> <td style="border: none;">Wave/Twist in Tube ☐</td> <td style="border: none;">Instructions Incomplete/Unclear ☐</td> <td style="border: none;">Part Lost/Missing ☐</td> </tr> <tr> <td style="border: none;">Marks/Chatter ☐</td> <td style="border: none;">Drill Holes ☐</td> <td style="border: none;">Part Moved ☐</td> </tr> <tr> <td></td> <td></td> <td style="border: none;">Drawing ☐</td> </tr> <tr> <td></td> <td></td> <td style="border: none;">Finish ☐</td> </tr> <tr> <td></td> <td></td> <td style="border: none;">Misread ☐</td> </tr> <tr> <td></td> <td></td> <td style="border: none;">Turning Sequence ☐</td> </tr> </table>			Crimp/Kink/kippie/wave ☐	Inspection incomplete/Unqualified ☐	Positioned Wrong ☐	Cuffs ☐	Contamination ☐	Outside Dimensions ☐	Crushing ☐	Countersink ☐	Over/Under tolerance ☐	Heat Treat ☐	Cut Too Short ☐	Part Incorrect ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Part Lost/Missing ☐	Marks/Chatter ☐	Drill Holes ☐	Part Moved ☐			Drawing ☐			Finish ☐			Misread ☐			Turning Sequence ☐
Environment ☐	No Re-verification ☐																																																									
Design ☐	Operator ☐																																																									
Doc/Data ☐	Offset/Setup ☐																																																									
Equip/Tooling ☐	Supplier ☐																																																									
Handling/Pre ☐	Training ☐																																																									
Material ☐	Use for Testing ☐																																																									
Internal Transport ☐	Poor Information ☐																																																									
Tribal Knowledge ☐	Rushing ☐																																																									
LOA ☐	Product Improvement ☐																																																									
Substation ☐	Process Improvement ☐																																																									
Past Expiry Date ☐	Manufacturing Process ☐																																																									
Misidentified ☐	Past Due ☐																																																									
Crimp/Kink/kippie/wave ☐	Inspection incomplete/Unqualified ☐	Positioned Wrong ☐																																																								
Cuffs ☐	Contamination ☐	Outside Dimensions ☐																																																								
Crushing ☐	Countersink ☐	Over/Under tolerance ☐																																																								
Heat Treat ☐	Cut Too Short ☐	Part Incorrect ☐																																																								
Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Part Lost/Missing ☐																																																								
Marks/Chatter ☐	Drill Holes ☐	Part Moved ☐																																																								
		Drawing ☐																																																								
		Finish ☐																																																								
		Misread ☐																																																								
		Turning Sequence ☐																																																								
OTHER : _____																																																										